DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/Ala Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-017807
Date Inspected: 29-Oct-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 1900
OSM Departure Time: 700
Location: Shanghai, China

CWI Name:	See below	**CWI Present:**	☑ Yes ☐ No
Inspected CWI report:	☐ Yes ☑ No ☐ N/A	**Rod Oven in Use:**	☑ Yes ☐ No ☐ N/A
Electrode to specification:	☑ Yes ☐ No ☐ N/A	**Weld Procedures Followed:**	☑ Yes ☐ No ☐ N/A
Qualified Welders:	☑ Yes ☐ No ☐ N/A	**Verified Joint Fit-up:**	☐ Yes ☑ No ☐ N/A
Approved Drawings:	☑ Yes ☐ No ☐ N/A	**Approved WPS:**	☑ Yes ☐ No ☐ N/A
		Delayed / Cancelled:	☐ Yes ☑ No ☐ N/A

Bridge No: 34-0006
Component: Tower and OBG Components

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10
This QA Inspector randomly observed the following work in progress in Bay 10:

SMAW tack welding of weld joint BK004A2-025-018 located on PCMK OBG BK004-025, bottom plate to bottom plate. Welder was identified as 061938. QC was identified as ZPMC CWI Qiu Wen (QC1). Welding variables recorded by QC1 appeared to comply with WPS-B-P-2211 as verbally identified by QC1.

Bay 11
This QA Inspector randomly observed the following work in progress in Bay 11:

SMAW tack welding of weld joints BK004A6-022-070, 078, 088, 098 located on PCMK OBG BK004-022. Welder was identified as 040611. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Xu Jie (QCA1), who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-P-2212 as verbally identified by QCA1.

FCAW welding of weld joints GGL-MQ-1958-051~060-001, 002 located on PCMK's OBG GGL-MQ-1958-051~060, welded channel splice. Welder was identified as 040723. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was QCA1, who

was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-T-2231-TC-U4b-F as verbally identified by QCA1.

OBG Trial Assembly Area
This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

SMAW welding of weld joint OBW11-029 located on PCMK OBG 11CW upper counterweight attachment plate to edge plate. Welders were identified as 041713, 057333. QC was identified as ZPMC CWI Shi Lei (QC2). Also present at this location and appearing to be monitoring the welding and recording data were ZPMC QC Leader Gu Rong Jian and ABF Representative Zhang Qi Li. Welding variables recorded by QC2 appeared to comply with WPS-B-P-2214-B-U2 as verbally identified by QC2.

SMAW tack welding of weld joints SP636-001-008~012 located on PCMK OBG 11BE/11CE transverse joint, side plate T-stiffener web to side plate T-stiffener web, north (crossbeam) side. Welder was identified as 042280. QC was identified as QC2. Welding variables recorded by QC2 appeared to comply with WPS-B-P-2113-FCM-1 as verbally identified by QC2.

SMAW tack welding of weld joints SP556-001-050~056 located on PCMK OBG 11BE/11CE transverse joint, side plate T-stiffener web to side plate T-stiffener web, north (crossbeam) side. Welder was identified as 040532. QC was identified as QC2. Welding variables recorded by QC2 appeared to comply with WPS-B-P-2113-FCM-1 as verbally identified by QC2.

Heavy Dock
This QA Inspector randomly observed the following on the Heavy Dock:

All 4 towers, lift 4 were positioned on a base separate pedestal at end of the Heavy Dock. No work was being performed on any of the tower components and no ZPMC floating cranes were moored to the Heavy Dock or in the area. A ship was moored to the end of the Heavy Dock.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:
As noted above.
Comments
This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng, 159-2184-5703, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer